

5/03

DART AEROSPACE LTD	Work Order :	Z2009
Description: LUG BRACKET	Part Number:	D2735-1
Drawing: D2735 REV. <i>PC</i> <i>dm 99.08.09</i>	Qty:	54 50

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	<i>DM</i>	04.12.01	50
2	PURCHASING	Issue P/O: <i>1007232</i> Make per Drawing D2735 Material release note required	<i>DM</i>	04/12/16	50
3	RECEIVING	Receive and Inspect for transit damage Ensure the material release note attached	<i>CD</i>	04/12/15	50
4	QC	Level 6 inspection per Master part Dwg and QSP 019	<i>DC</i>	04.12.16	50
5	METAL	Bend per Drawing D2735 Use CNC Brake Jig DT8204	<i>DC</i>	05.01.11	54
6	QC	Inspect Level 5	<i>DC</i>	05/01/12	54
7	STORES	Identify and Stock	<i>CD</i>	05/01/12	54
8	EXPEDITING	Close W/O Cost / part <i>41.90</i> <i>50</i> <i>05/01/13</i> <i>54</i>	<i>DM</i>	05.01.14	54

Rev	Date	Change	Revised By	Approved
A	98.01.19	New Issue	BW	
B	98.11.16	Re-format, Changed steps	DM	<i>DS</i>

MANUFACTURER RELEASE CERTIFICATION

D.O.T Approval 9-89

The aeronautical product described hereon conforms to approved type design data and is in a condition for safe operation.

Authorized Inspector

Date

RELEASED
dm 99.08.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

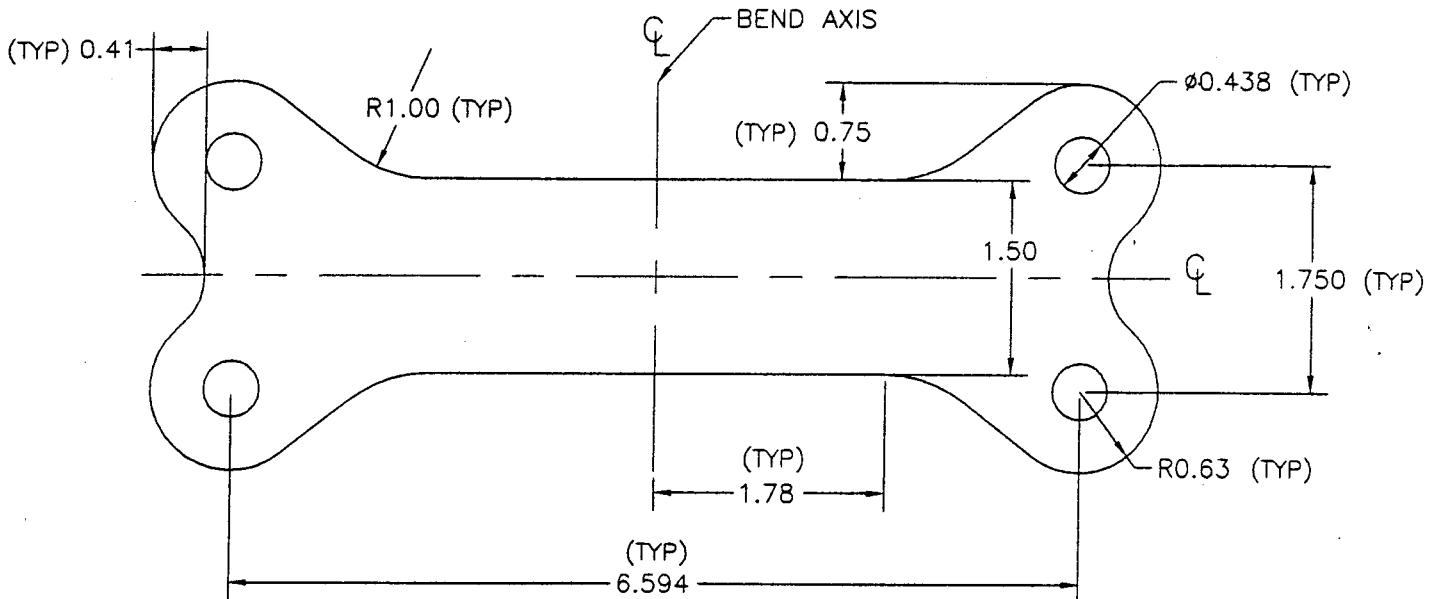
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

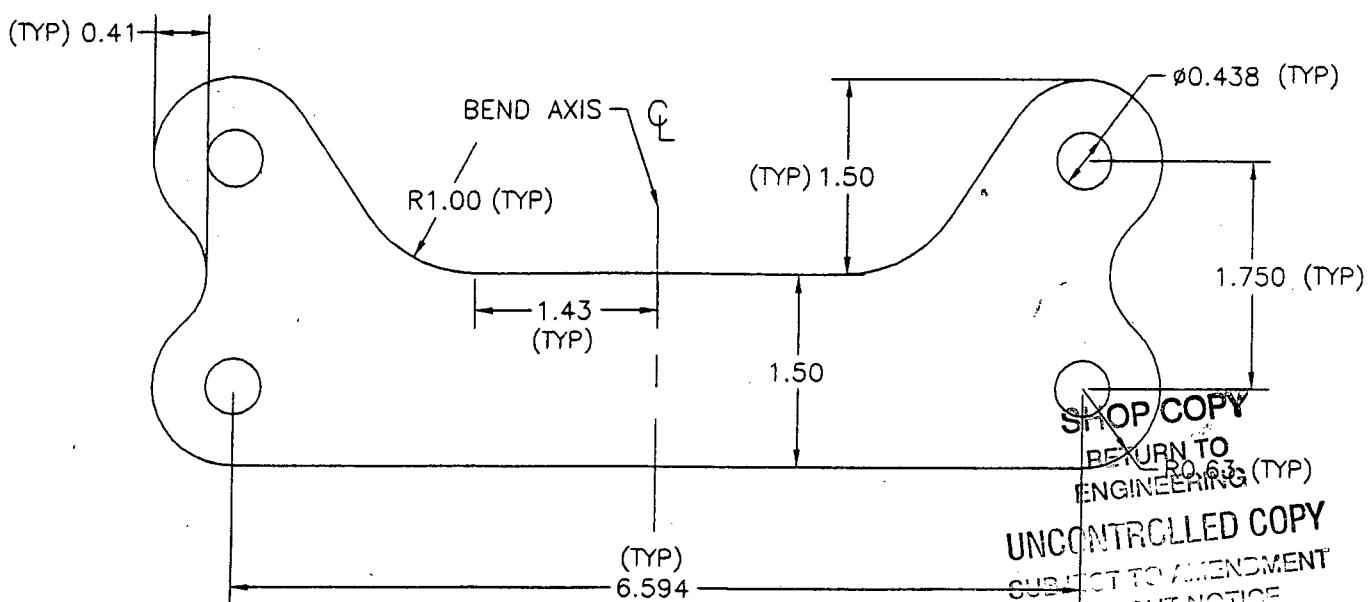


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2735
DATE		REV. C
98.12.14		SHEET 1 OF 2
		SCALF.
		2:3

RELEASED
98.12.14 DS



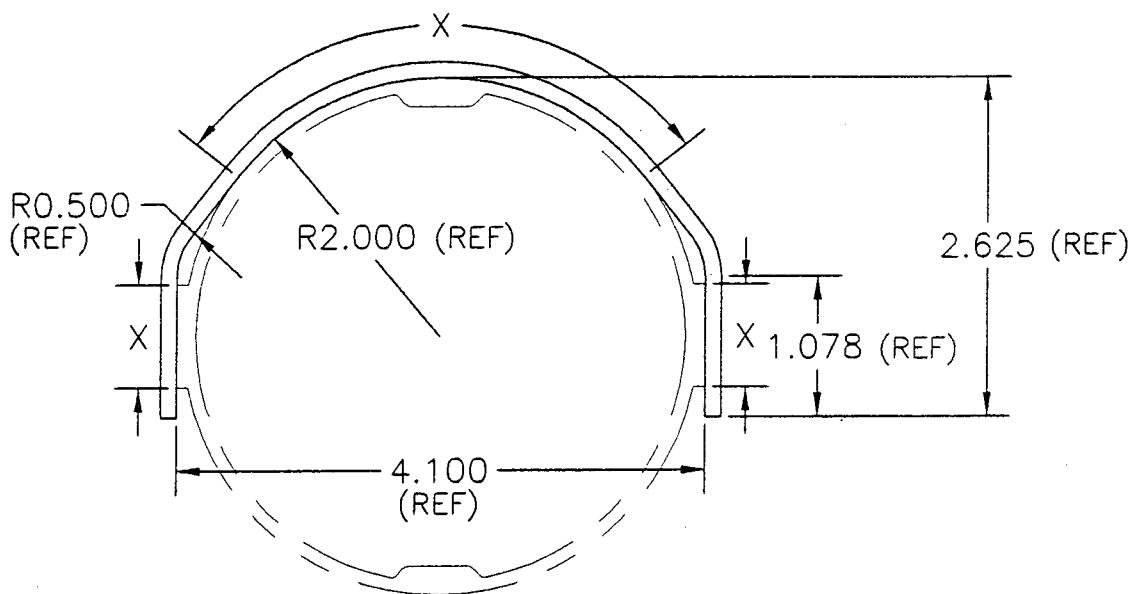
D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (C)



D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (C)

DART

DESIGN <i>MM</i>	DRAWN BY <i>MM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DSD2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)

MIN. ULTIMATE TENSILE STRENGTH = 42 ksi

MIN. YIELD TENSILE STRENGTH = 28 ksi

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUB. TO AMENDMENT

W/ CUT NOTICE

WORK ORDER

NO. 22009

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 01, 2004
07:31 am

Work Order No : 0022009
 Project Name : D2735-1
 Project For : WK503
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2735-1
 Description : Lug Bracket
 Manufactured : Yes
 Amount Req'd : 50
 Amount Done : 0
 Start Date : 11-30-04
 Est Finish Date : 01-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00		
===== ===== =====					
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00



BHP New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephone: (09) 3758 999 Auckland
(08) 2358 069 Waikato
Fax (09) 3758 959 Telex 24936

TEST CERTIFICATE

Ref: 9852301

CUSTOMER		Wilkinson												SPECIFICATION		ASTMA569				CERTIFICATE No		TC027066		
CUSTOMER Q/N		90-31N-067												PRODUCT		HOT ROLLED PICKLED & OILED				PAGE		1 of 1		
MILL Q/N		256321												DIMENSIONS		0.119" x 48" x Coil				DATE		22 November 2000		
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT												MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)										
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	()	LENGTH (feet)
		x100		x1000												x10000		x100		180°	G.L.=			
HP-720792-00	602612	6	TR	21	9	18	12	18	22	4	6	1								Good				820
HP-720793-00	602612	6	TR	21	9	18	12	18	22	4	6	1								Good				827
HP-720794-00	602612	6	TR	21	9	18	12	18	22	4	6	1								Good				817
HP-720795-00	602612	6	TR	21	9	18	12	18	22	4	6	1								Good				830
HP-720796-00	602612	6	TR	21	9	18	12	18	22	4	6	1								Good				807
HP-720797-00	602612	6	TR	21	9	18	12	18	22	4	6	1								Good				810

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 / So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=45 (B)=r00 (D)=(r0+r00+2/45) / 4	IMPACT TEST (A)=10mm x 10mm (C)=5mm x 5mm (B)=7.5mm x (D)=2.5mm x	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Antish Misra
QC METALLURGIST